

**ABSTRACT**

A method and apparatus for integrating a new or transferred pallet into a conveyor system. The present invention provides a first conveyor for carrying a plurality of adjacently aligned pallets along a predetermined path of travel. A first motor is coupled to the first conveyor for driving the adjacently aligned pallets at a first rate of speed. A first encoder is coupled to the first motor for monitoring the position of the last pallet of the adjacently aligned pallets on the first conveyor. A second conveyor carries and introduces a new pallet to the first conveyor. A second motor is coupled to the second conveyor for driving the new pallet at a second rate of speed, and a second encoder is coupled to the second motor for monitoring the position of the new pallet. A computer processor determines the relative positions of the last pallet relative to the new pallet for determining the second rate of speed of the new pallet so as to adjacently align the new pallet and the last pallet within a predetermined docking area. A controller adjusts the second rate of speed of the second motor in response to a signal from the computer processor.